

Work Order ID 68204

Friday, April 08, 2011 11:47:53 AM



Page 1

Item ID:	D3578-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	4/8/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	4/12/2011	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	12-04-8	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3578	Rev A								

100		0.00							
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	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3578 (Run prog. D3578-1)								
6061 .080	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
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QC	Memo	0.00							
Quality Control									

(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3578-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/8/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Open rivet holes to 0.098" and C'sink as per dwg D3578								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

E. B. / 04 / 14 (50)

M 11 - 04 - 14 (50)

50 *phi* 11 - 04 - 18

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				50		BR 11-4-18-	
170 Small Fab Small Fab	Small Fab Memo I-Assemble as per dwg D3578	0.00 0.00							EP 11/04/18 (50) (10)
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							counts (X30)

8/10/19

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Stop



Item Name: Doubler

Start Date: 4/8/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 245A

0.00



Packaging

Memo

0.00

Packaging

PC 11/4/20 50

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/20 50
11/04/20

*ME**11-04-20*

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NOTE: Date & initial all entries

Picklist Print

Friday, April 08, 2011 11:48:00 AM

Page 1
T

Work Order ID: 68204

Parent Item: D3578-041

Parent Item Name: Doubler




Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A ☐ 07.04.11 ☐ New issue ☐ EC ☐
IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3  Rivet		Purchased	No			110	Each	3,389.000	2	80			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				3389					
					19099			3389					
M6061T6S.080  6061-T6 .080 Sheet		Purchased	No			170	sf	442.5000	0.007	0.294737			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				442.5					
				116268				40.5					
				116700				66					
				117285				336					
MS21075L3  Nutplate		Purchased	No			170	Each	159.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST303				159					
				116513				9					
				116706				150					

Handwritten notes and signatures:
 8/54/04/18
 100
 11-4-11
 50
 116700
 8/11/04/18
 50

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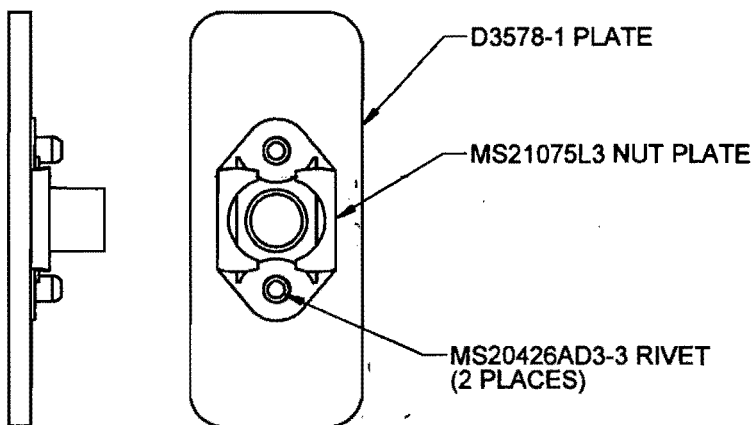
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12		TITLE DOUBLER	SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

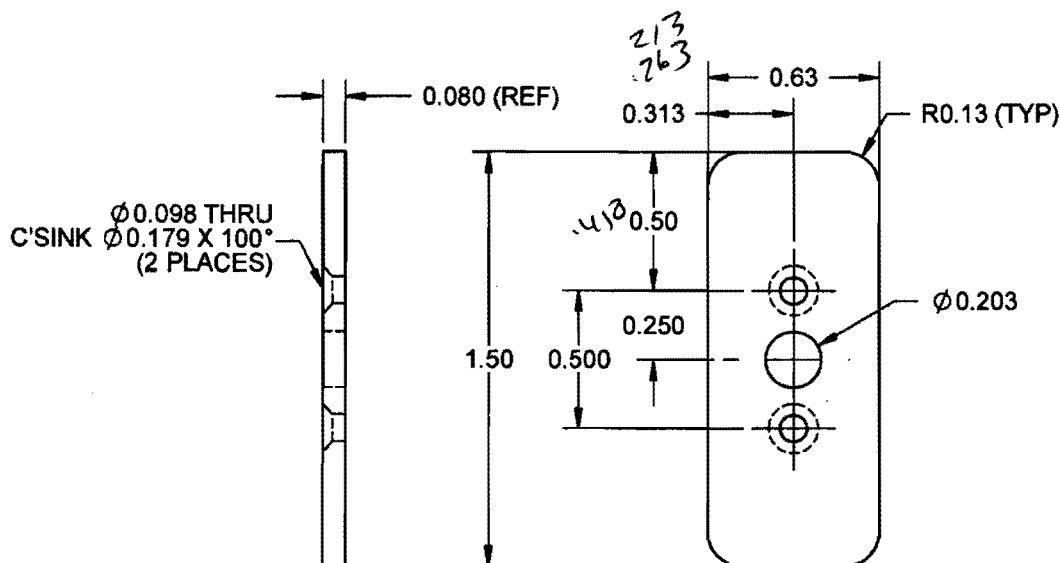
**RELEASED**
07.04.02 #8**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER**D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68204
PL 11-04-8

**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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